










Date: Friday, 1/6/2006 1:44:30 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L /407 STEP ASSY, LH
<b>Job Number</b>	: 24383A		
<b>Estimate Number</b>	: 11702		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D2724041
<b>This Issue</b>	: 1/6/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2724 REV C
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: C
<b>Written By</b>	: SEE COMMENT BELOW	<b>Material</b>	: N/A
<b>Checked &amp; Approved By</b>	: SEE COMMENT BELOW	<b>Due Date</b>	: 1/13/2006
<b>Comment</b>	: Est Rev:E As Per Ecn 766 06-01-06 JLM	<b>Qty:</b>	3 <b>Um:</b> Each
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	D2622120C	Extrusion	
			
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Qty Part # Description Batch:			
1 D2622-120C Extrusion <u>324092</u>			
Check Material for any Dents or Defects			
<i>L.L. 06.01.9</i> 3			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
			
<b>Comment:</b> LARGE FABRICATION RESOURCE 1			
Cut D2724-1 using D2622 extrusion as per Dwg D2724			
Deburr and bevel ends for welding			
<i>L.L. 06.01.9</i> 3			
3.0	D2734	206 Step Endplate	
			
			
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
206 Step Endplate			
Pick:			
Qty Part Number Description Batch			
2 D2734 End Cap <u>320757</u>			
<i>L.L. 06.01.9</i> 3			
4.0	D34581	PLATE	
			
			
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
2 D3458-1 Plate <u>325209</u>			
<i>L.L. 06.01.9</i> 3			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/6/2006 1:44:30 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 24383A

Part Number: D2724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34583	PLATE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	325210

*LE 06.01.9*

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig  
~~DT (One-End Only)~~

A/R AL ROD Batch: *m18838 m18839*

Grind end cap welds flush

*Temporarily made by  
Hand (this time only,  
S.g. to be creamed next time)*

*06.01.11*

7.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

*06.01.10*

*PD  
06.01.10*

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FF 06-01-10*

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06.01.11*

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024



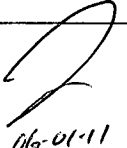
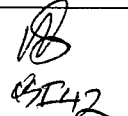

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT

A/R AL ROD Batch: *m18838 m18839*

*06.01.11*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: Q7 Date: 06/01/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
06-01-11	10	Piece of grinding pad was left inside of the step, and wasn't removed before the end cap was welded on.		Remove end cap to original dims. of the step length (as per Dwg) and remove any the foreign object inside. Clean edge of step, and replace end cap to <del>10057</del> weld as per Dwg, and grind flush. See Attached Tech E-mail.	 06-01-11 <u>B20757</u>	 06-01-11	 06-01-11	 06-01-11

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 24383A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



PD  
06-01-11 (3)



Comment: WELD INSPECTION

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FF 06-01-12

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 06-01-15 3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

ML 06 01 15 3

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 06/01/18 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ✓

CL 06/01/18 (3)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

CL 06/01/18 (3)

Job Completion



U 06-01-18 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

## Jason Murdoch

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**From:** David Shepherd [davids@dartaero.com]  
**Sent:** January 11, 2006 3:00 PM  
**To:** Jason Murdoch  
**Subject:** Re: a step

With respect to your repair, this is acceptable to me.

With respect to the jerseys, sounds good to me. If I have a choice, I'll take # 5.

David

----- Original Message -----

**From:** Jason Murdoch  
**To:** [davids@dartaero.com](mailto:davids@dartaero.com)  
**Sent:** Wednesday, January 11, 2006 12:52 PM  
**Subject:** a step

Good day

I have a step that after it was cleaned out after alodine for foreign objects, the end of his soft wheel was left inside the step. The wheel was used to remove the alodine before welding. The end cap was fully welded on, and now it has to be removed to get that piece out. We should be able to do so without changing the dims. Of the length. Is this ok with you. By the way we got two sets of jerseys wht and red, Carrolina style NHL.

[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

**Q.C. Inspector**